

Date: Thursday, 17/04/2008 10:59:09 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
 Job Number : 38653  
 Estimate Number : 10530  
 P.O. Number :  
 This Issue : 17/04/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 17/04/2008 Type : MACHINED PARTS  
 Previous Run : 37921  
 Part Number : D2571  
 Drawing Number : D2571 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 01/05/2008 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.4.17  
 Comment : Est: 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 Saddle Billet



Comment: Qty: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: \_\_\_\_\_

5x 31389  
 3x34875

28 08/05/05

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 28 Double check by: JLD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

DIP / 28 08/05/05

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

DIP 08/05/11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/05/10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 17/04/2008 10:59:10 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 38653

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/05/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

WR/m-f

08/05

(8X)

30min

15/05/2008

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107925

m-f

08/05

S.249 1.59

#1 318.8 F

#2 B38653 F

#3 02571 F

#4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BL

08-05-15

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS

08/05/15

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/16

Job Completion



MF 08-05-16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38053
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	.443	.443	.443		
B	1.745	1.755		1.746	1.750	1.750	1.750		
C	3.495	3.505		3.497	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.008	7.998	7.999	7.999		
F	0.490	0.510		0.506	.490	.501	0.496		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		0.502	.503	.505	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	.578	.579	.579		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.131	.131	.131	.132		
Q	0.115	0.135		0.135	.135	.135	.132		
R	0.240	0.260		.258	.258	.258	.258		
S	0.115	0.135		0.134	.132	.135	.131		
T	0.178	0.198		.180	.184	.184	.184		
U	2.940	2.980		2.964	2.962	2.962	2.962		
V	0.230	0.250		0.240	.245	.247	.246		
W	0.115	0.135		0.124	.123	.125	.135		
X	0.308	0.313		.312	.312	.312	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.365	.365	.368	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.625	.635	.628	0.630		
AC	0.053	0.073		0.062	.062	.062	0.062		
AD	0.240	0.260		0.250	.250	.250	.250		
AE	1.375	1.395		1.392	1.385	1.384	1.384		
AF	0.115	0.135		0.130	.135	.135	.135		
AG	0.240	0.280		.260	.265	.265	.265		
AH	0.240	0.260		0.251	.258	.259	.257		
AI	2.000	2.020		2.007	2.002	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DJP
Date:	08/05/06 / 08/05/08

Audited by:	SA
Date:	08/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38653
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				51	62	73	84		
A	0.438	0.443		0.443	0.443	0.443	0.443		
B	1.745	1.755		1.750	1.750	1.748	1.749		
C	3.495	3.505		3.500	3.498	3.499	3.499		
D	1.745	1.755		1.750	1.748	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.510	0.506	0.5045	0.504		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.505	.508	0.506	0.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.575	.578	0.574	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.132	.130	.124	.120		
Q	0.115	0.135		.135	.135	0.135	0.135		
R	0.240	0.260		.260	.248	.249	.248		
S	0.115	0.135		.132	.131	0.132	0.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.245	.247	0.246	0.234		
W	0.115	0.135		.133	.133	0.135	0.122		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.363	0.363	0.364	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.630	0.627	0.630	0.632		
AC	0.053	0.073		0.0625	0.0625	0.0625	0.0625		
AD	0.240	0.260		.250	.250	.250	0.243		
AE	1.375	1.395		1.383	1.384	1.384	1.3895		
AF	0.115	0.135		.135	.135	.135	0.135		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.246	0.243		
AI	2.000	2.020		2.003	2.003	2.003	2.0035		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	SR
Date:	08/05/14

Audited by:	SR
Date:	08/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

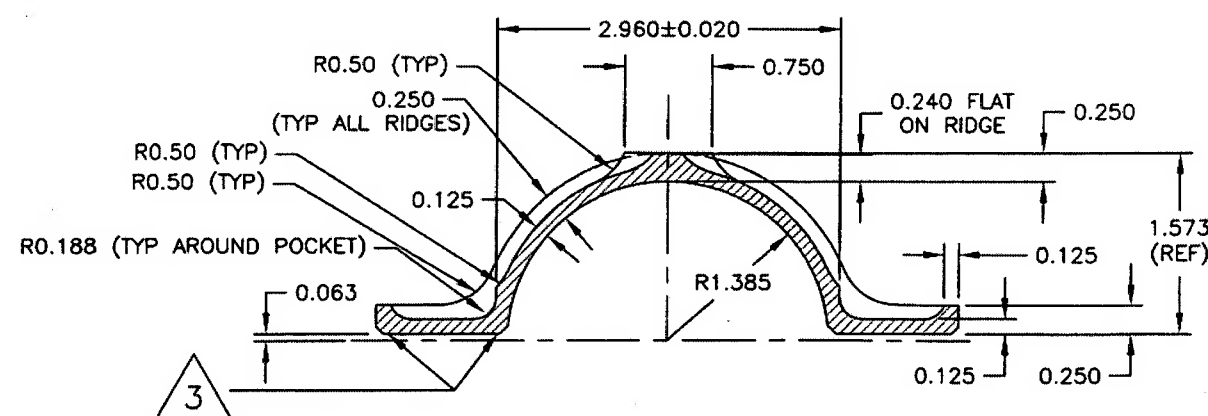
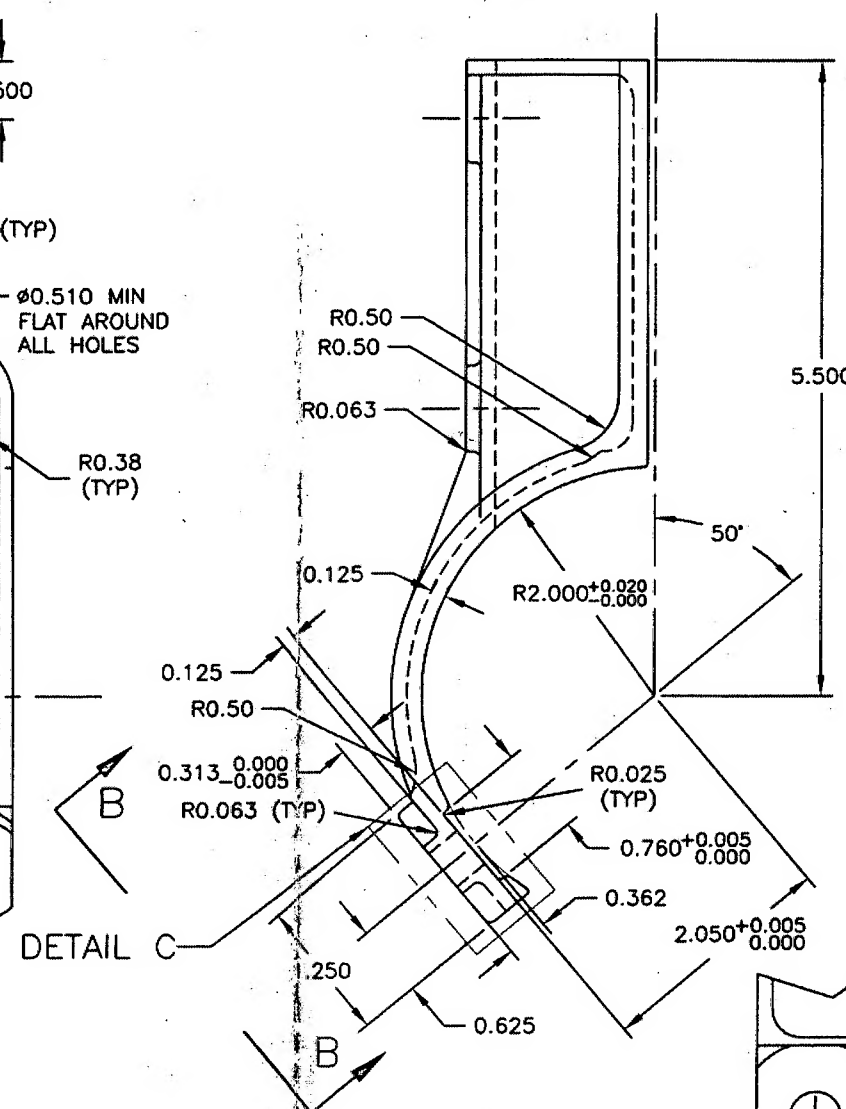
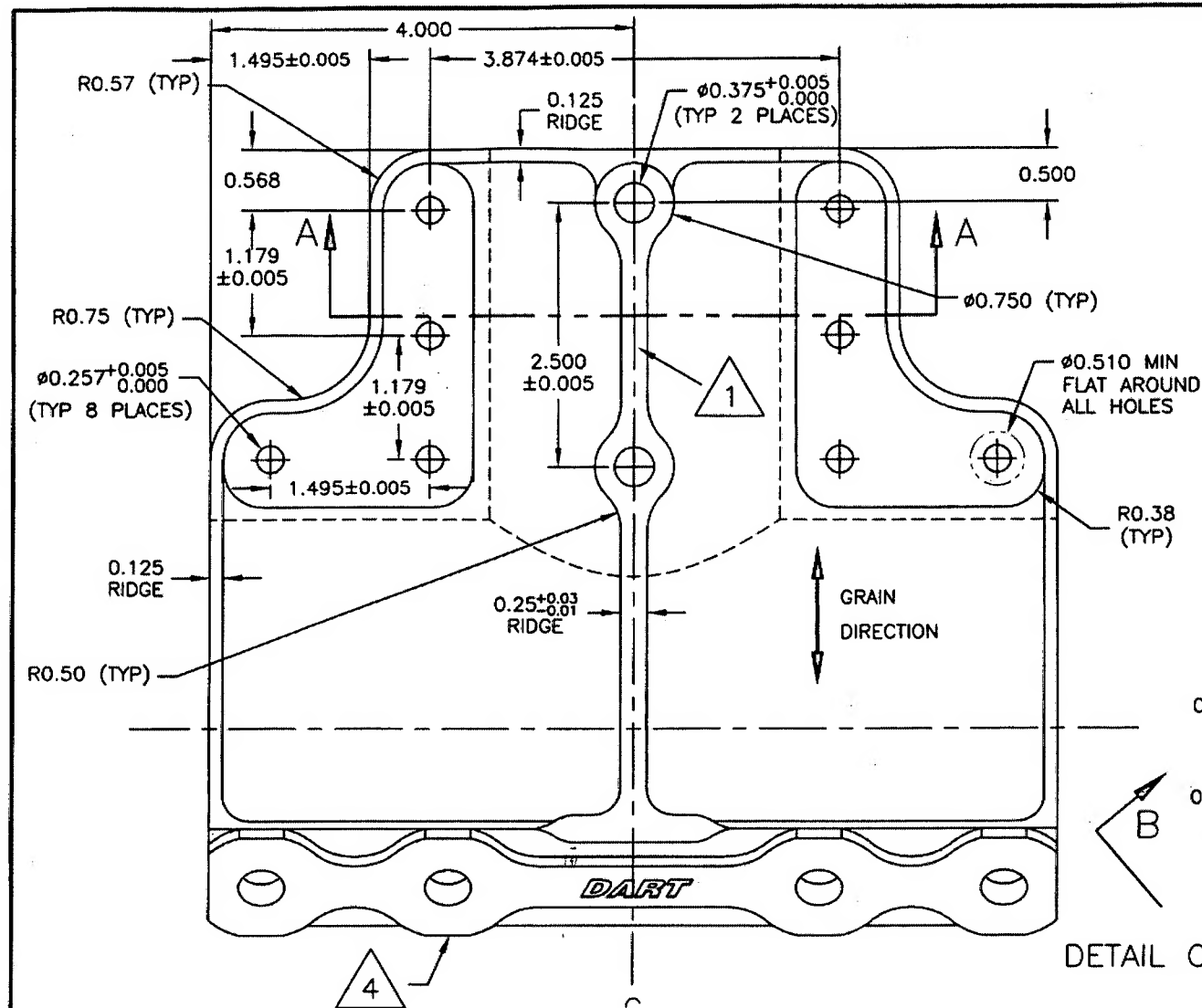
05.12.13

# NOTES

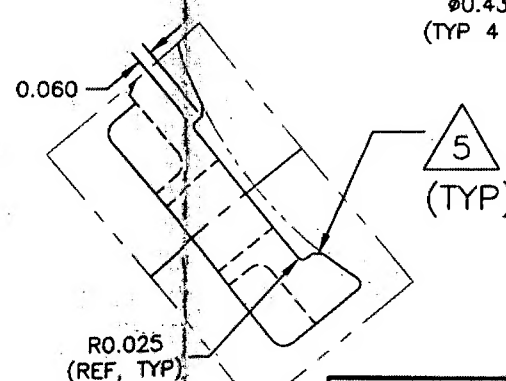
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

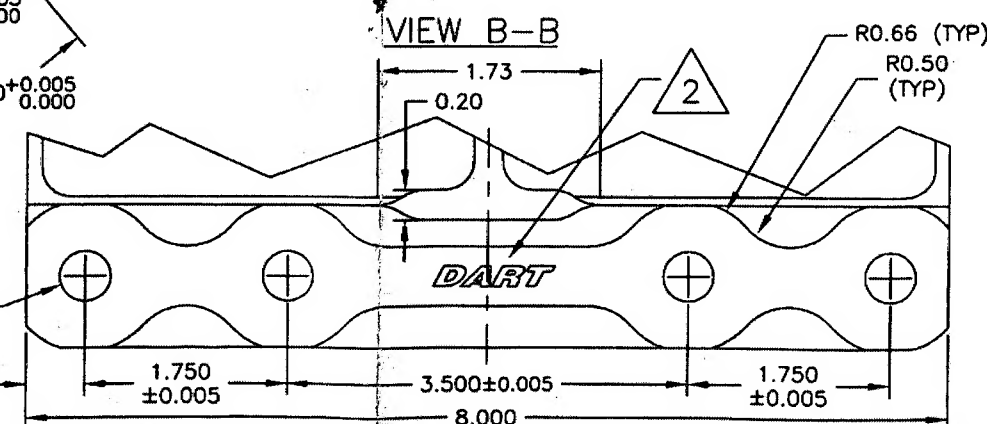
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 CONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 38653



SECTION A-A



DETAIL B  
 SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.02.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN DS	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HAYKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2571
DATE 05.07.13	TITLE OUTER FWD SADDLE	REV. E SHEET 1 OF 1 SCALE 2:3

